



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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646.9702

Job Sheet 190725



008606

Part No: 646.9702

Job Qty: 3 pcs

Part Name: Cutter Sub Assembly (U Channel)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/13/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG 646.9702 REV.F IPP REV:A NEW ISSUE JFS 13/07/03 VERIFY BY: DD

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                        |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 110   | Packaging 1 - Pick Kit | 3 pcs | 3/22/19    |          | 0.00      | 0.00    | Packaging 1 - 1       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 2       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 3       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 4       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 5       |           | DAS      |
|       |                        |       |            |          |           |         | Packaging 1 - 6       |           | 28       |
|       |                        |       |            |          |           |         | Packaging 1 - 7       |           | 9-89     |
|       |                        |       |            |          |           |         | Packaging 1 - 8       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 9       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 10      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 11      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 12      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 13      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 14      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 15      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 16      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 17      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 18      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 19      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 20      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 21      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 22      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 23      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 24      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 25      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 26      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 27      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 28      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 29      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 30      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 31      |           |          |



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Container No: S161759



Part: 646.9702

Job No: 190725

Serial No/Batch: S161759

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 03/12/19

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|                                 |       |         |           |                        |                  |      |
|---------------------------------|-------|---------|-----------|------------------------|------------------|------|
|                                 |       |         |           |                        | Packaging 1 - 32 |      |
|                                 |       |         |           |                        | Packaging 1 - 33 |      |
|                                 |       |         |           |                        | Packaging 1 - 34 |      |
|                                 |       |         |           |                        | Packaging 1 - 35 |      |
|                                 |       |         |           |                        | Packaging 1 - 36 |      |
|                                 |       |         |           |                        |                  |      |
| 120 Small Fab - 2 - B4B         | 3 pcs | 3/22/19 | 0.00 1.70 | Small Fab - 1 - B4B    |                  |      |
|                                 |       |         |           | Small Fab - 2 - B4B    |                  |      |
|                                 |       |         |           | Small Fab - 3 - B4B    |                  | DAS  |
|                                 |       |         |           | Small Fab - 4 - B4B    |                  | 36   |
|                                 |       |         |           | Small Fab - 5 - B4B    |                  | 9-89 |
|                                 |       |         |           | Small Fab - 6 - B4B    |                  |      |
|                                 |       |         |           | Small Fab - 7 - B4B    |                  |      |
| 130 QC 5                        | 3 pcs | 3/22/19 | 0.00 0.00 | QC 5 - 10              |                  |      |
|                                 |       |         |           | QC 5 - 12              |                  |      |
|                                 |       |         |           | QC 5 - 17              |                  |      |
|                                 |       |         |           | QC 5 - 18              |                  |      |
|                                 |       |         |           | QC 5 - 19              |                  |      |
|                                 |       |         |           | QC 5 - 22              |                  |      |
|                                 |       |         |           | QC 5 - 24              |                  |      |
|                                 |       |         |           | QC 5 - 3               |                  |      |
|                                 |       |         |           | QC 5 - 42              |                  |      |
|                                 |       |         |           | QC 5 - 43              |                  |      |
|                                 |       |         |           | QC 5 - 49              |                  |      |
|                                 |       |         |           | QC 5 - 51              |                  |      |
|                                 |       |         |           | QC 5 - 58              |                  |      |
|                                 |       |         |           | QC 5 - 68              |                  | DAS  |
|                                 |       |         |           | QC 5 - 9               | MAR 1 8 2019     | 40   |
|                                 |       |         |           | QC 5 - 50              |                  | 9-89 |
|                                 |       |         |           | QC 5 - 30              |                  |      |
|                                 |       |         |           |                        |                  |      |
| 140 Packaging 3-1 - Stock - B4B | 3 pcs | 3/22/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |                  |      |
|                                 |       |         |           | Packaging 3 - 2 - B4B  |                  |      |
|                                 |       |         |           | Packaging 3 - 3 - B4B  |                  |      |
|                                 |       |         |           | Packaging 3 - 4 - B4B  |                  |      |
|                                 |       |         |           | Packaging 3 - 5 - B4B  | DAS              |      |
|                                 |       |         |           | Packaging 3 - 6 - B4B  | 26               |      |
|                                 |       |         |           | Packaging 3 - 7 - B4B  | 9-89             |      |
|                                 |       |         |           | Packaging 3 - 8 - B4B  |                  |      |
|                                 |       |         |           | Packaging 3 - 9 - B4B  |                  |      |
|                                 |       |         |           | Packaging 3 - 10 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 11 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 12 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 13 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 14 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 15 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 16 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 17 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 18 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 19 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 20 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 21 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 22 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 23 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 24 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 25 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 26 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 27 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 28 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 29 - B4B |                  |      |
|                                 |       |         |           | Packaging 3 - 30 - B4B |                  |      |

|                |       |         |           |                        |  |
|----------------|-------|---------|-----------|------------------------|--|
|                |       |         |           | Packaging 3 - 31 - B4B |  |
|                |       |         |           | Packaging 3 - 32 - B4B |  |
|                |       |         |           | Packaging 3 - 33 - B4B |  |
|                |       |         |           | Packaging 3 - 34 - B4B |  |
|                |       |         |           | Packaging 3 - 35 - B4B |  |
|                |       |         |           | Packaging 3 - 36 - B4B |  |
| 150 QC 21 - SA | 3 pcs | 3/22/19 | 0.00 0.00 | QC 21 - SA - 21        |  |
|                |       |         |           | QC 21 - SA - 70        |  |
|                |       |         |           | QC 21 - SA - 53        |  |

Part Op 110 - (Pick Kit)  
 Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note . A/R RTV LOCTITE  
 598: \_\_\_\_\_ exp. date: \_\_\_\_\_  
 130 - (QC5- Inspect part completeness to step on W/O)  
 140 - (Identify as per dwg & Stock Location: \_\_\_\_\_) \*\*\*IDENTIFY AS PER IAW MPP-120\*\*\*  
 150 - (QC21- Final Inspection - Work Order Release)

| Job BOM         |                |               |                            |           |
|-----------------|----------------|---------------|----------------------------|-----------|
| Part / Item     | Component Name | Quantity      | Operation                  | Container |
| 646.9711 CCK107 | Blade          | 6 pcs (2 ea)  | 110-Packaging 1 - Pick Kit | 5104600   |
| 646.9712 15A    | Body           | 3 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 5109918   |
| MS21042L08 ST   | Nut            | 18 Ea (6 ea)  | 110-Packaging 1 - Pick Kit | 5134219   |
| MS27039-08-19   | Screw          | 18 Ea (6 ea)  | 110-Packaging 1 - Pick Kit | 5104359   |
| NAS1149FN832P   | Washer         | 36 Ea (12 ea) | 110-Packaging 1 - Pick Kit | 5143716   |

| Job Allocations            |                |          |           |           |
|----------------------------|----------------|----------|-----------|-----------|
| Operation                  | Component Part | Required | Inventory | Allocated |
| 110-Packaging 1 - Pick Kit | 646.9711       | 6        | 31        | 0         |
|                            | 646.9712       | 3        | 10        | 0         |
|                            | MS21042L08     | 18       | 1,299     | 0         |
|                            | MS27039-08-19  | 18       | 821       | 0         |
|                            | NAS1149FN832P  | 36       | 3,124     | 0         |

| Part Specifications                |  |
|------------------------------------|--|
| Specifications could not be found. |  |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|--------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                        |              |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                        | MRB (QSI042) |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Disposition            |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Completed By           |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Lead hand / Supervisor |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | QC / QA Coordinator    |              |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |                        |              |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        |              |  |